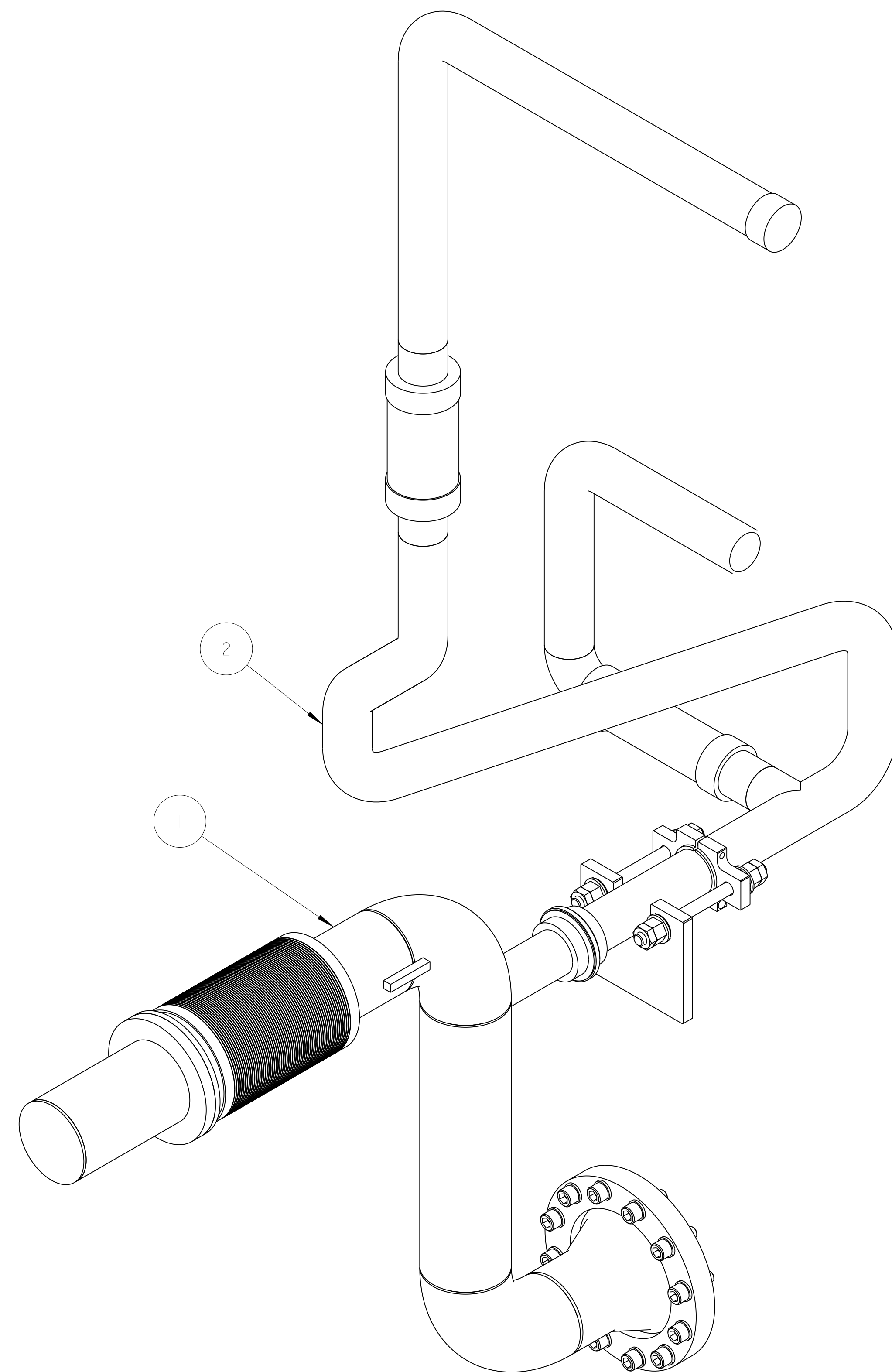
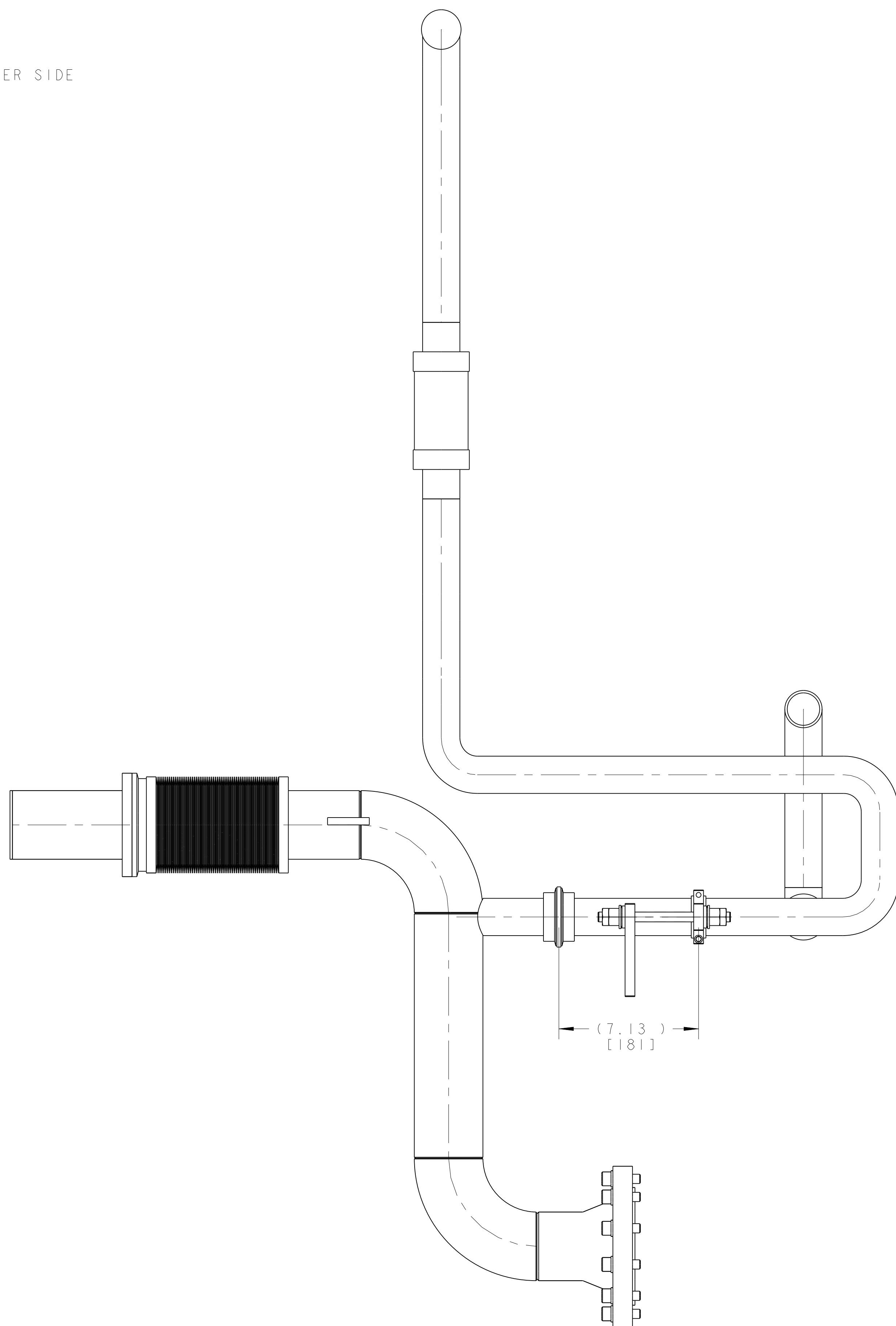



1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:
PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,
OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES
ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO
LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE
FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
11. REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY
AND CLEAN ENDS.
12. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS
WITHIN +/- .010.
13. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989.
14. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING
FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH
THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL,
TO AN ACCURACY OF $\pm 0.063"$.
15. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE
ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR
PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX
ASSEMBLY.
16. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE
OF THE CENTER-PLANE OF THE SUPPORT.
17. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS.



SCALE 5 / 16

THIRD ANGLE PROJECTION

				UNLESS OTHERWISE SPECIFIED				SHOP ORDERS				SOP NO.		ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY 			
TOLERANCES				X.X ± 0.1				ACQ. NO.				DATE					
X.XX ± 0.03				FAC. ± 1/64				NO. 1000				DATE					
X.XXX ± 0.010				Angles ± 1.00°				FIN. 12/32				DATE					
DO NOT SCALE PRINT				SURFACE				TOLER.				DATE		LHC IR FEEDBOX CRYOGENICS PIPE WELDMENT, LD2 AND BUS DUCT			
THREADS ARE CLASS 2				FINISH 12/32				TOLER.				DATE					
COUNTER ENDS ARE ALL SCREW THREADS 30°				METHOD				TAG				DATE					
CUT ROUNDS, 1/8 THREAD RELIEF ON MACHINED THREADS				PROJECT				NUMBER				DATE					
SCREW ENDS (SEE VIEW) ON MACHINED SURF.				DRAWN				DATE				DATE		MICROFILMED: ENG. TYPE SHOWN ON SCALE: 9/32 ASSEM SHEET 1 OF 2 PATENT CLEAR: DESIGN ACT. NO. CATEGORY CODE Dwg. NO. 2515576 REV.			
IN ACCORDANCE WITH NIA 104.18.1 (44.1)				NO. 1000				DATE				DATE					
CUT ROUNDS, 1/8 THREAD RELIEF ON MACHINED THREADS				DATE				DATE				DATE					
SCREW ENDS (SEE VIEW) ON MACHINED SURF.				DATE				DATE				DATE					
INITIAL REVISIONS				DATE				DATE				DATE		SHEET 1 OF 2 PATENT CLEAR: DESIGN ACT. NO. CATEGORY CODE Dwg. NO. 2515576 REV.			
CHANGES				DATE				DATE				DATE					
DATE				DATE				DATE				DATE					
DATE				DATE				DATE				DATE					

